DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-014836
Date Inspected: 05-Jun-2010

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 700
OSM Departure Time: 1900
Location: Shanghai, China

CWI Name:	Li Yang and Wu Zhi Cheng	**CWI Present:**	☑ Yes ☐ No
Inspected CWI report:	☐ Yes ☑ No ☐ N/A	**Rod Oven in Use:**	☐ Yes ☐ No ☑ N/A
Electrode to specification:	☐ Yes ☐ No ☑ N/A	**Weld Procedures Followed:**	☐ Yes ☐ No ☑ N/A
Qualified Welders:	☐ Yes ☐ No ☑ N/A	**Verified Joint Fit-up:**	☐ Yes ☐ No ☑ N/A
Approved Drawings:	☐ Yes ☐ No ☑ N/A	**Approved WPS:**	☐ Yes ☐ No ☑ N/A
		Delayed / Cancelled:	☐ Yes ☐ No ☑ N/A

Bridge No: 34-0006
Component: OBG Trial Assembly

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, S. Manjunath Math was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

Orthotropic Box Girder (OBG) Trial Assembly Areas

Segment 8CW to 9AW (Skin Flatness) Joint Survey

This QA Inspector performed Joint Inspection along with Caltrans QA Mr. Manoj Prabhune and with ABF Survey Team for the Skin Flatness between Segment 8CW to 9AW (Shop Segment Splice) between Panel Point (PP) 71 and PP 72 North.

(Counter Weight side at B1 and B2 locations) and South (Cross Beam side at B3 and B4 Locations) at weld connecting Bottom Panel to Side Panel with 5000mm String line for overall deformation and 600mm and 630 mm Straight Edge for localized deformation and

(Counter Weight side at T1 location) and South (Cross Beam side T2 Location) at weld connecting Deck Panel to Edge Panel with 5000mm String line for overall deformation and 600mm and 630 mm Straight Edge for localized deformation.

The measured readings were recorded on spread sheet, generated the report and submitted to the Task Leader and Engineer for review.

Segment 8AE to 8BE (Longitudinal Diaphragm) Joint Survey

This QA Inspector performed Joint Inspection with ZPMC Survey Team and ABF Survey Team for the Longitudinal Diaphragm between Segment 8AE to 8BE (Shop Segment Splice) between Panel Point (PP) 64 and PP 65 North (Cross Beam side) for Offset and Sweep. The offset was measured at 5 (five) different locations in which 2 (Two) locations were at Flange area and 3 (Three) locations were at Web area and Sweep was measured at 100 mm from both side from the Floor Beam and 800mm from both side of floor Beam and at Centre (Total 5 Locations). The measured readings were recorded on spread sheet, generated the report and submitted to the Task Leader and Engineer for review.

Segment 11AW (Green Tag DCP)

This QA Inspector performed Green Tag DCP along with Mr. Manoj Prabhune for the following Segment 11AW from Panel Point (PP) 95, PP 96 to PP 97.

Corner Assembly Cope Holes dimension measurements at PP 95, PP 95.5, PP 96, PP 96.5, PP 97 and PP 97.5 Cross Beam and Counter Weight Side.

Plumbness and Flatness measurement for Deck Panel to Deck Panel Diaphragm at PP 95, PP 96 and PP 97 from East and West Side.

Flatness measurement for Floor Beam at PP 95, PP 96 and PP 97 Cross Beam and Counter Weight Side.

Skin Flatness for Side Panel to Corner Assembly Counter Weight side and Cross Beam side from PP 94.75 to PP 97.75.

Skin Flatness for Deck Panel to Corner Assembly Counter Weight side and Cross Beam side from PP 94.75 to PP 97.75.

The measured readings were recorded on spread sheet, generated the report and submitted to the Task Leader and Engineer for review.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric T Sang 1500-0042-2372, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By:	Math,Manjunath	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer